

Work Order ID 76332

76332

Page 1

November-09-11 8:36:07 AM

Item ID: D4035-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Rib Assembly, Fwd (350 Basket)
 Start Date: 09/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 23/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

100

Large Fab

Large Fab

Memo

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

0.00

11/11/09 (4x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

11/11/09

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(44)			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Basket all Memo	0.00 0.00				11/11/09		(4x)	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				11/11/14			

11-11-11
(4)

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Picklist Print

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Page 1

Work Order ID: 76332

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Parent Item: D4035-041

D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

23.0000

1

2

D2327-3

Spacer Bushing

**

W 11/11/09

Location

Loc Qty

Loc Code

WA

23

72963

3

74782

20

(4x)

M304TS0.750W.049

Purchased

No

100

f

351.7527

1.75

3.684211

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

W 11/11/09

Location

Loc Qty

Loc Code

MAT018

326.9754839

117775

93.6739

118472

47.1990839

118880

51.2404

119147

134.8621

MAT034

1.8507

117337

1.8507

WA

22.92654

118184

22.92654

7.36 + 1 END BAR SCRAP

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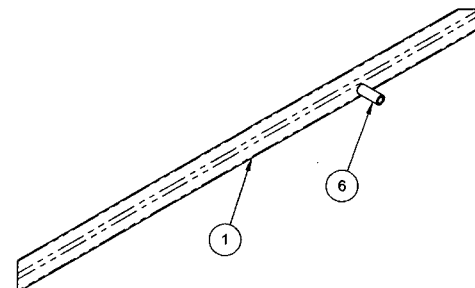
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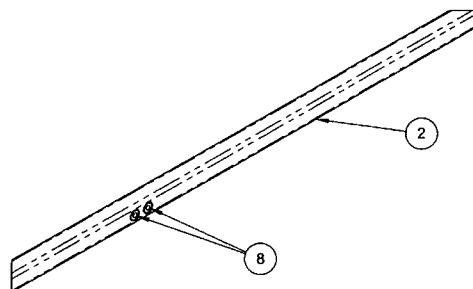
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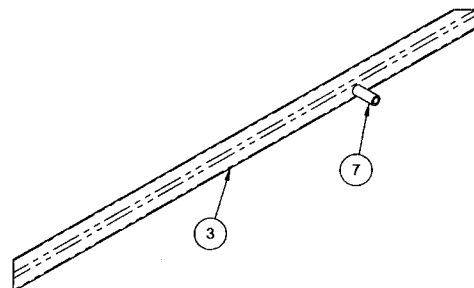
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



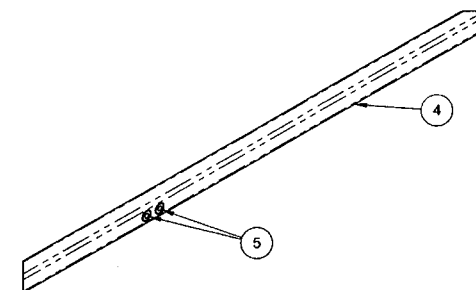
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36332 M.C.5
11/11/09

RELEASED
2010-03-12

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4035	SHEET 1 OF 5		
APPROVED		TITLE	SCALE		
DE APPR.		BASKET LID RIB ASSY	NTS		
DATE	10.03.04				
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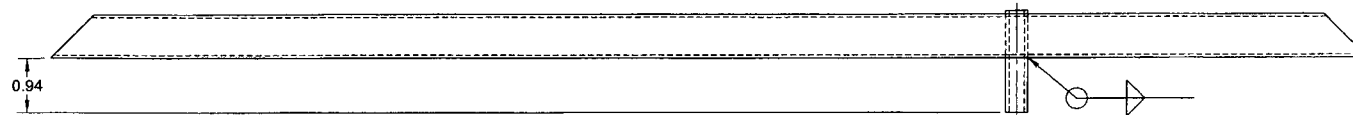
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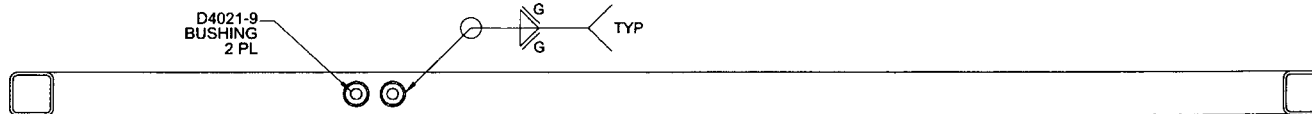
76332



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4021-9
BUSHING
2 PL

D4035-3
RIB

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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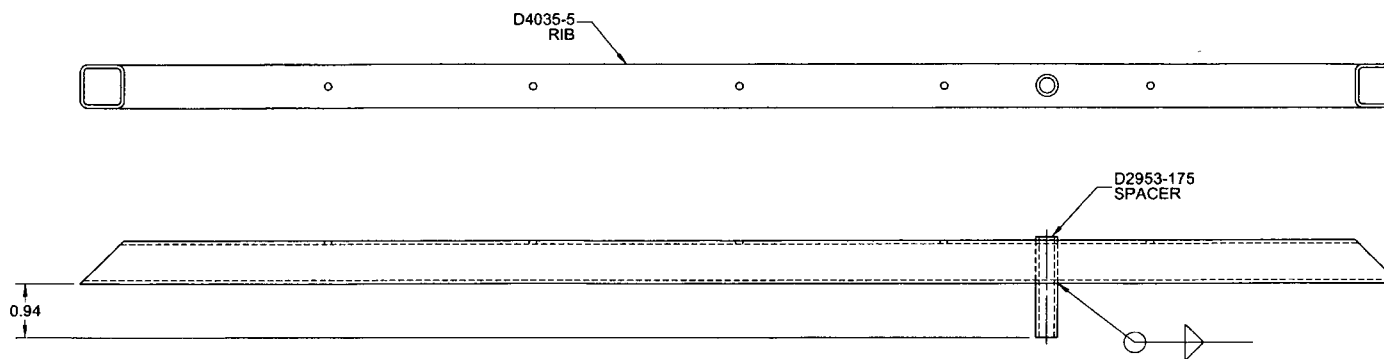
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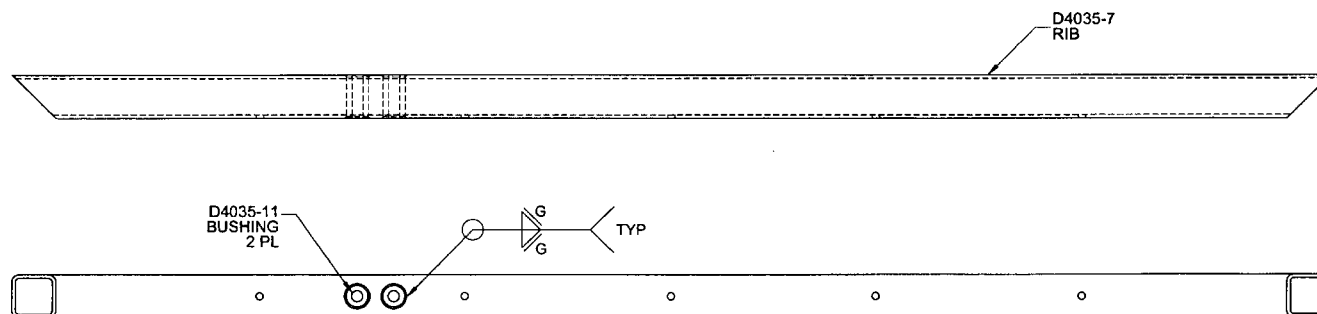
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D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
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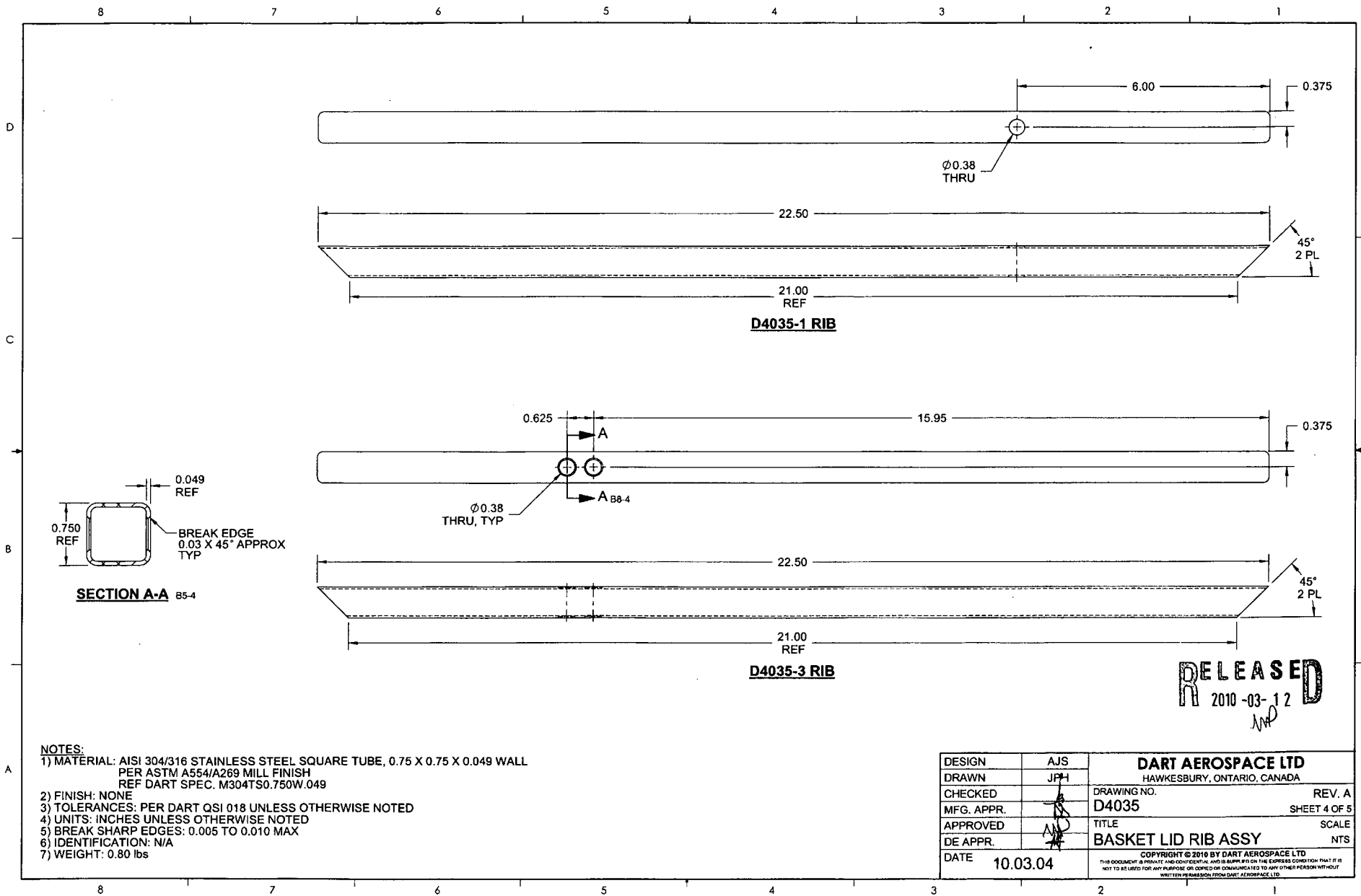
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.80 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 4 OF 5
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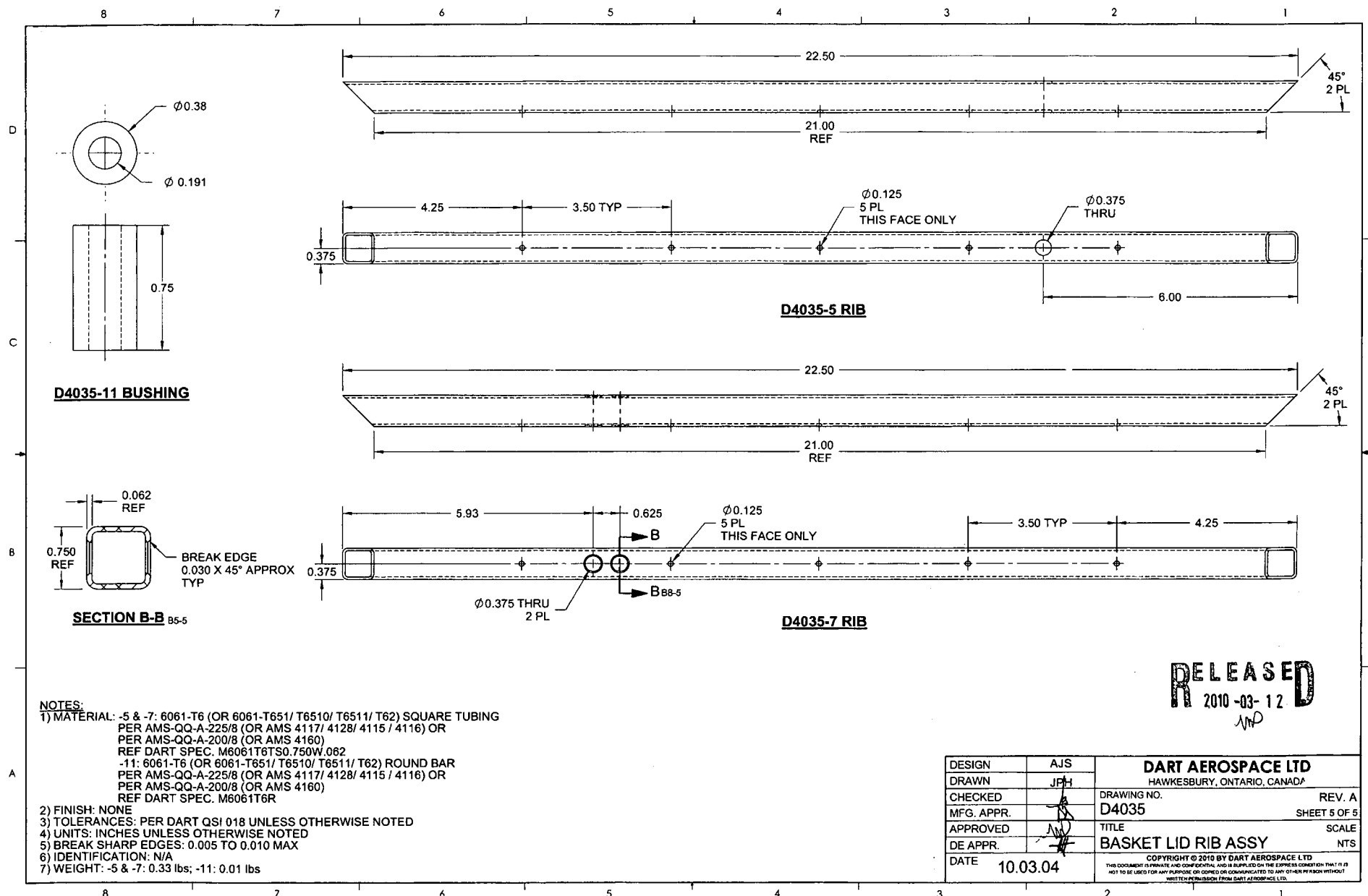
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